

Work Order ID 60458

July 9, 2010 2:42:35 PM

Page 1

Item ID: D3201-1

Accept

Revision ID:

Item Name: Doubler

Setup Start

Stop

Start Date: 7/09/10 Start Qty: 12.00

Required Date: 7/13/10 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3201

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3201 Dwg Rev: B Prog Rev: B 12-
Deburr if necessary

2024.040

SP 10/07/21

10-7-21

(14)

(14)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-7-21

Pro →

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8.10.21

(FIC)

(X3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3201-1 PAR #: _____ Fault Category: Small Fals NCR: ☒ Yes ☐ No DQA: [Signature] Date: 10/07/26
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/08/26

NCR: <u>60458</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/7/21	# 120	Found qty x3 Parts with large ^{deep} scratch / Score along the parts. (Depth of marks From 0.005 to 0.008")	<u>[Signature]</u> 10/5/14/2	- SCRAP QTY 3 No replace	<u>[Signature]</u> 10-7-21	<u>[Signature]</u> 10/6/21	<u>[Signature]</u> 10/5/14/2	<u>[Signature]</u> 10/6/21
		PL mat. handling / Revision in with marks.	<u>[Signature]</u> 10/5/14/2					<u>[Signature]</u> 10/6/21

NOTE: Date & initial all entries

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Item ID: D3201-1

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Setup Start



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Start Date: 7/09/10 Start Qty: 12.00



Cust Item ID:

Required Date: 7/13/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Deburr Stack

0.00

0.00

ES 10/07/21



140



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

11 BR 10-7-21

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

ml 10 07 21 (17)

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Start Date: 7/09/10

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Required Date: 7/13/10

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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 40

0.00



Packaging

Memo

0.00

Packaging

10-7-22

11x 5/

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/23

MF
10-7-22

Picklist Print

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Page 1

Work Order ID: 60458

Parent Item: D3201-1

Parent Item Name: Doubler



Start Date: 7/09/10

Start Qty: 12.00

Required Date: 7/13/10

Required Qty: 12.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-25 JLM
IPP Rev:B Now on Waterjet 06-08-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	407.4400	0.276	3.486316	3.864		

M2024T3S.040



2024-T3 .040 sheet



1810-7-21

Location

Loc Qty

Loc Code

MAT	96	
114415	96	
MAT22	311.44	
110305	80.33	
111786	13.76	
112291	28.25	
112331	52	
113162	137.1	

110368

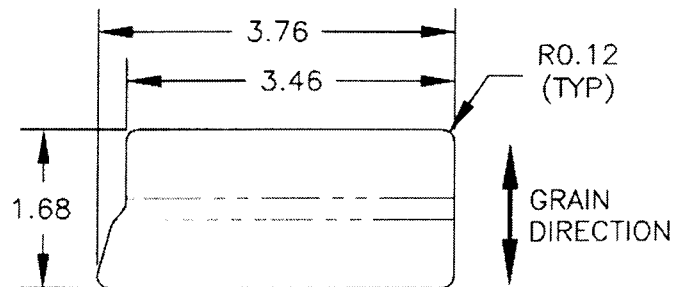
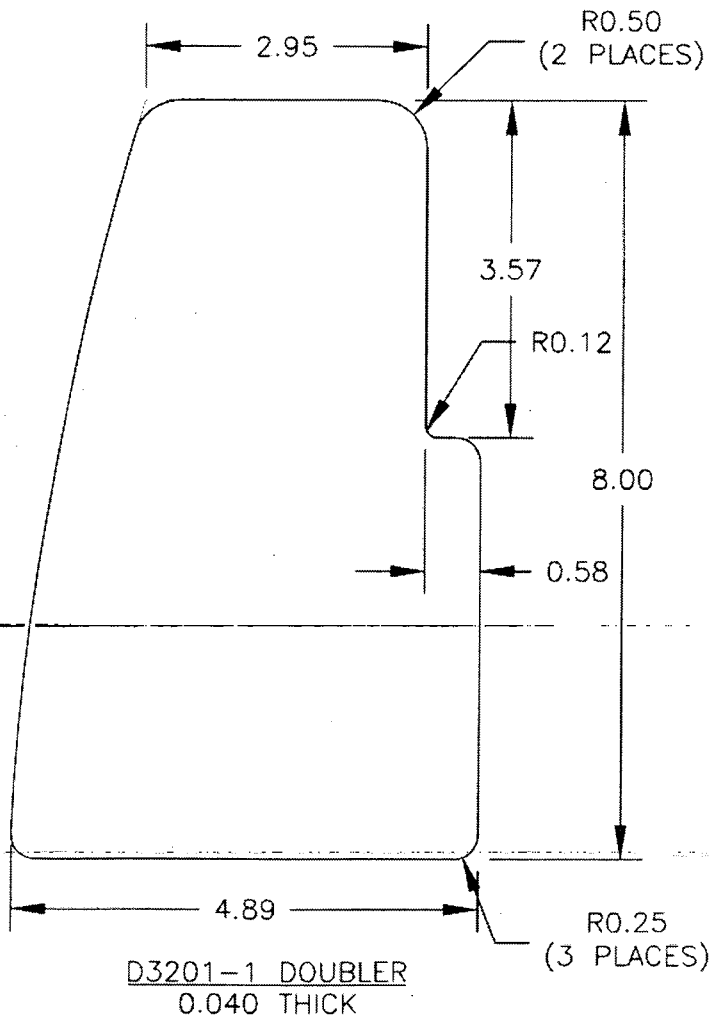
14



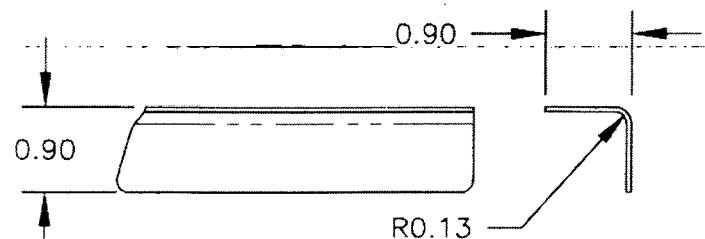
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3201	REV. B SHEET 1 OF 1
DATE 03.11.03		TITLE DOUBLER	SCALE 1:2
A	03.08.07	NEW ISSUE	
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4	

03.11.04

W/D 60458



D3201-3/-4 ANGLE
(FLAT PATTERN)



D3201-3 ANGLE (SHOWN)
D3201-4 ANGLE (BEND OPPOSITE)
0.050 THICK

D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI-005 4:1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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